

ABSTRACT:

A method of controlling a process of electrochemically machining an electrically conductive workpiece employing the spectral composition of the measured voltage within a predetermined measuring period such as induced by an applied current between the electrically conductive workpiece and an electrode tool. A process of 5 electrochemically machining employing a material removing step with electric current supplied continuously and a workpiece shaping step with electric current supplied intermittently. An advantageous embodiment employs extreme short pulses.

Fig. 20

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